-				1012*						Page 1
Item ID: D350 Revision ID: Item Name: Bushin Start Date: 5/16/3 Required Date: 5/16/3	ng 14 Start Qty: 240.0	/	=	*N900 Cust Item I Customer:		100)* §	Setup Star Stop	171	S1* S2*
Approvals: Proc	cess Plan: MUD	Date: 14-05-0	Tooling:	Da	ate:	_	F	Run Star	~1/1	R1*
QC:		Date:	_ SPC (Y/N):	Da	ate:			Stop	, *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		A STATE OF THE STA	MA MALE ATTE						
D3501	Rev A		٠							
1 \\n Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE Memo 1-TURN A REV:	S PER FOLIO FA650 & D DWG REV:	0.00 0.00 WG D3501 ,FOLIO 2-DEBURR AS REQUIRE	ED			242			DAS 25 9-89/4/5-1(c
*110 * *110* QC Quality Control	QC2- Inspect parts off a	machine FAI/FAIB	0.00				24Q			DAS 25 9-89 /4 5-12
120 *1 On* QC Quality Control	QC8- Inspect parts - sec	cond check	0.00	_			242	_ <u>B</u> _		14/05/16

P

DQA:			Date:											TQAG"
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	ar.					DISPOSITION				AGAINST D	PARTMENT,	/PROCESS		
WOIK OIG	-1.					Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	Nο					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
1 4721					_	Use-as-is			noforming	Finishing	-1	re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite	j ,	Supplier		П
						· · · · · · · · · · · · · · · · · · ·	,				_			
Root					Desc	ription of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verificatio	<u> </u>	QC Inspector
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Doc/Data			i											
Equip/Tooling														
Handling/Pre							İ							
Material		,												
Operator $t^{\cdot k}$	r.													
Offset/Setup														
Process ^*												-		
Supplier														
Training														
Transport														
Unapproved! *	_							UT CAT	FECORY					
<u> </u>	•						FA	ULI CA	TEGORY					
Landi	ng (Bending				General Bend		ا دمانه (۵	Program		Outside Dim	encions		Pressure/Forced
		Centre No	ot Concen	tric		BOM/Route	\vdash	Grain	Togram		Over/Under		-	Set-up
	\vdash	Cracks	or concern	itiit		Broken/Damage/Defect	\vdash	Hardwa	aro		Part Incorred			Temperature/Cure
		Crimp/Kir	k/Rinnle	/Wave		Burrs	┝		ion Incomplete/Un	gualified	Part Lost/Mi		一	Weld
	\vdash	Cuffs	iky itippic,	wave		Contamination	H	{ `	tions Incomplete/U	·	Part Moved	33.116	-	Wrong Stock Pulled
!		Crushing				Countersink		4	gned/off center	_	Positioned V	ا Vrong		
	 	Heat Trea	it			Cut Too Short		Mislabe	=	F	Power Loss/	-		Other
		Inspection		Tube		Drawing		Misread		L	-	-		
		Marks/Ch	•			Drill Holes	Г	Off-set						
		Turning S				Finish	Г	Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence	<u> </u>				

Work Order ID 119012 *119012* May-06-14 8:09:32 AM D3501-1 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Bushing **Start Date: Start Qty: 240.00** *240* 5/16/14 **Cust Item ID:** Required Date: 5/16/14 Reg'd Oty: 240.00 *240* **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: **Tooling:** Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept **Work Center ID Description Qty** Oty Code Number **Run Hours** 130 Identify as per dwg & Stock Location: 0.00

140

QC21- Final Inspection - Work Order Release

0.00

0.00

87082

140

120

Packaging

Packaging

QC

Memo

Memo

0.00

Quality Control

MCJ MOS-21

Insp.

Stamp

Page 2

DQA:			Date:						_				TRAC
						WORK ORDER NON-	-CC	ONFO	RMANCE / UF			–	AEROSPACE
QA Closed:			Date:								Vork Order u	pdate only	
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIR OIG	-''-					Rework	ı		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality
	-				_	Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	۱o			.—.		Suspected Unapproved			Large Fab	Composite		Supplier	
D 1				i	Desc	intian of work and a sundata		nitial	Acti	ion	Cian 9.	ì	
Root		Data	Chan	O4	Desci	ription of work order update or non-conformance		nitial ief Eng	1		Sign & Date	Verification	QC Inspector
Cause	\dashv	Date	Step	Qty		or non-comormance	CII	ilei Elig	Descr	iption	Date	Verification	QC IIIspector
Design Doc/Data	\dashv												
Equip/Tooling	\dashv					}					İ		
Handling/Pre											İ		
Material													
Operator													
Offset/Setup			:										
Process													
Supplier													
Training	ヿ								İ		,		
Transport	П						1						
Unapproved													
							FAI	ULT CA	TEGORY				
Landi	ng G	iear				General				_		_	
		Bending				Bend			Program		Outside Din	 	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	<u> </u>	Set-up
	-	Cracks				Broken/Damage/Defect	L	Hardwa		_	Part Incorre	 	Temperature/Cure
·		Crimp/Kir	nk/Ripple	/Wave		Burrs		1 '	ion Incomplete/Un	, -	Part Lost/M	· -	Weld
	ш	Cuffs				Contamination		4	tions Incomplete/U	Jnclear	Part Moved	_	Wrong Stock Pulled
		Crushing				Countersink	<u> </u>	4	gned/off center	L	Positioned		¬
		Heat Trea		٠	<u> </u>	Cut Too Short	\vdash	Mislabe		L	Power Loss,	/Surge	Other
	$\boldsymbol{-}$	Inspection	•	Tube	<u> </u>	Drawing		Misrea					
	⊢—	Marks/Ch			_	Drill Holes	<u> </u>	Off-set					
	-	Turning S				Finish	\vdash	4	Calibration				
		Wave/Tw	ist in Tub	oe -		Fit/Function	1	Out of	Sequence				

Picklist Print

May-06-14 8:09:31 AM

Work Order ID: 119012

119012 D3501-1

Parent Item Name: Bushing

D3501-1

Start Date: 5/16/14

Required Date: 5/16/14

Page 1

Start Qty: 240.00

Required Qty: 240.00

Comments:

Parent Item:

IPP Rev:A New Issue 06-05-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Prim Item Loca	•	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M303R0.750		Purchased	No		100	f	128.7820	0.0791	20		
M303B0	75 0							**		V	14-5-16

M303R0 750

303 Round Bar 0.750

Location	Loc Oty	Loc Code	
MAT028	128.782		
m127464	48.948		
m128882	79.834		1 20.4 1

DQA:	<u> </u>		Date:			WORK ORDER NON	~	SNICOL	ONANNICE / III	DDATE				~DART
QA Closed:			Date:			WORK ORDER NON-	-00	JINFOI	NIVIAIVCE / UI		W	ork Order up	odate only	AEROSPACE
Marili Ond						DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
Work Orde	er: -	····				Rework	ı		Skid-tube	Crosstube		1	Water Jet	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
, a.c.	-					Use-as-is			noforming	Finishing		4	re/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite		'	Supplier	
							•							
Root					Desci	ription of work order update	1	nitial	Act	ion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
Design														
Doc/Data														
Equip/Tooling	Ш													
Handling/Pre														
Material	Ц											:		
Operator														
Offset/Setup												<u> </u>		
Process														
Supplier	Щ													.4
Training														
Transport						•								
Unapproved					<u> </u>		<u> </u>					<u></u>		<u> </u>
						• • • • • • • • • • • • • • • • • • • •	FA	ULT CAT	TEGORY					
Landi						General	ι	15.0.75]		Outside Dim		Pressure/Forced
	-	Bending				Bend BOM/Boute		1	rogram			₹	-	Set-up
	Н	Centre No	ot Concer	ntric		BOM/Route	┝	Grain				Over/Under	 	Temperature/Cure
	\vdash	Cracks	. I. /D: 1 -	6.4.	<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		م الدانية		Part Incorred Part Lost/Mi		Weld
	-	Crimp/Kir	ік/кірріе,	/wave		Burrs	-	4 '	ion Incomplete/Ur	·		Part Moved	22111g	Wrong Stock Pulled
	\vdash	Cuffs			_	Countarink		4	ions Incomplete/U	Jiicieai		Positioned V	Vrong.	
	-	Crushing			-	Countersink Cut Too Short	\vdash	Mislabe	ned/off center		_	Power Loss/		Other
	Н	Heat Trea		Tubo		Drawing	\vdash	Misread			Щ	1. OME! 1022	Juige	Todici .
	Inspection Strip in Tube			Drill Holes	\vdash	Off-set	*							
	Marks/Chatter Turning Sequence		\vdash	Finish	\vdash	4	Calibration				,			
	-	Wave/Tw				Fit/Function	\vdash	4	Sequence					
	i I	TTUTC/ IV	SCHI IUD	·-	1	1	1	100001						

DART AEROSPACE LTD	Work Order:	119012
Description: Bushing	Part Number:	D3501-1
Inspection Dwg: D3501 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.850	+/-0.010	F18.			vern	-21-10
0.060	+/-0.005	-057	//			
Ø0.750	+0.008/-0.001+ op	7449				
Ø0.257	+0.005/-0.000	-260				
Ø0.472	+0.000/-0.002	,H71			mic	JL-42

						·

					·	

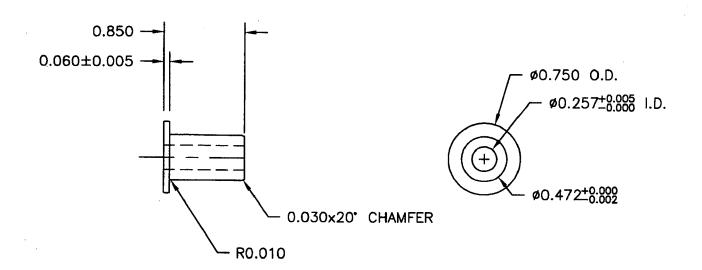
Measured by:	Jh.	Audited by:	On	Prototype Approval:	N/A
Date:	14-5-15	Date:	14/05/1/0	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.27	New Issue	KJ/JLM	Cill



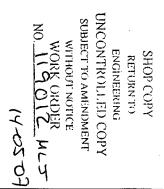


DESIGN P	DRAWN BY		SPACE LTD ONTARIO, CANADA
CHECKED /	APPROVED ML	DRAWING NO.	REV. A
#	911	D3501	SHEET 1 OF 1
DATE		TITLE	SCALE
06.04.18		BUSHING	1:1
Α	06.04.18	NEW ISSUE	



D3501-1 BUSHING

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES





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